

TECHNICAL SPECIFICATION

Hand die DIN 223, HSS-G, Metric Thread



Application

The main application of the die is cutting an external, metric standard thread pitch. The thread is cut on a cylindrical workpiece with a certain nominal diameter /specified in the technical data/. One die is used, the thread is cut at once along the entire length of the body. The die is also applicable for recovering damaged /crushed/ threads in bolts and studs.

The die is with cylindrical shape. It is mounded in a die stock. Fixation to the die stock is made by locking screws. It is important to start the thread cutting in a correct way – the die have to be perpendicular to the body on which the thread is cut. The thread is cut by turning the tap clockwise, slowly and evenly. To avoid tightening every 1 to 3 turns the tap is turned in the opposite direction by $\frac{1}{4}$ to $\frac{1}{2}$ turn. In this way the chips are cleared and the application of great effort is avoided.

It is recommended a coolant lubricant liquid to be used. The force of friction and the risk of breakage and wear are significantly reduced thanks to it.

Technical parameters

- Thread type: metric /M/, according to DIN 13
- Thread pitch: standard
- Thread direction: right
- Material: specialized HSS-G high strength steel

Die size	Outer diameter D / mm /	Height h / mm /	Diameter of cylindrical workpiece / mm /
M3 x 0.5	25	9	2.9
M4 x 0.7	25	9	3.9
M5 x 0.8	25	9	4.9
M6 x 1.0	25	9	5.9
M8 x 1.25	25	9	7.9
M10 x 1.5	25	9	9.8
M12 x 1.75	25	9	11.8

Advantages

- **Quality:** Specialized high strength steel HSS-G. High resistance of cutting edges and long service life.
- **Convenience:** Hand dies from M3 to M12 are with **EQUAL outer diameter and height – 25 mm x 9 mm**. This allows one die stock to be used for all dies. The die stock is according to DIN 225, 25x9 mm.
- **Practicality:** Easiness of usage and simplicity of the thread cutting operation.
- **Compactness:** Individual blister package.

